Work Orde September-11-1.		6 805 IM	46.3810	*1	റെ	305*							Page 1
Revision ID:	646.3810	6	106805	Accept		*N900	040	100)*	Setup	Start	171.	S1*
Item Name:	Bracket	a a a a.	4004								Stop	*N:	S2*
Start Date: Required Date: Reference:	9/23/13 9/23/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*			Cust Item II Customer:) :						
Approvals:	Process Pla	an: MUT	Date: 13-09-16	Tooling:		Da	te:	_		Run	Start	[7]	R1*
			•				te:		•		Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Ho	urs	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty	•	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr											
646.3800	N/C												
110				0.00									
110 Mill Conv		HAAS CNC VERTICAL Memo	. MACHINING #1	0.00	OAS 40 9-89	13/10/07			26	 ,			/13/10/09
Conventional Millin	g Machine	1-Machine f DWG REV:	Der DWG		9-69								
	•	2- deburr an	d break all sharp edges										
120 *120*		QC2- Inspect parts off m	achine FAI/FAIB	0.00					2/	,	Ŋ		12/10
120 QC Quality Control		Memo		0.00					26	/	<i>:</i>		<u>/ 1 </u>

NCR:	Yes	/	No
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NCR: Y	'es	/ No				,	WORK ORDER NON-C	:01	NFORM	ΛANCE / UP	DATE		DQA:	Da	te: _	
						T				``			QA Closed:	Da	te:	
Work Orde	r:					ł	DISPOSITION				AGAINST	T DE	PARTMENT	/PROCESS		
Part N	lo.						Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fat Finishing Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root				T	Desc	ripti	ion of work order update		nitial	Ac	tion		'Sign &		Т	
Cause		Date	Step	Qty			Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
oc/Data quip/Tooling Operator Material etup Other Trocess upplier												•				
raining Inapproved																
mapproved			L	l1			F/	L AUL	T CATE	GORY			1		1	
Landi	ng (Gear		*** * * * *			General		,					-		
		Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection Ripples in Torque W Turning S	Crimped t n Strip in Bend Yaves in E	Tube		B B C C C C C C C C C C C C C C C C C C	Send SOM/Route Broken/Damaged Surrs Sontamination Countersink Sut Too Short Orill Holes Orawing		Instruct Mainte Mislabe Misread Offset Out of O	on Incomplete ions incomplete/ nance led	'Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong		Pressure/Forced Femperature/Cure Weld Wrong Stock Pulled Other
		Wave/Tw	ist in Tul	эe		F	olio		Outside	Dimensions						

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord September-11-1				*10	680	75*						Page 2
Item ID: Revision ID: Item Name: Start Date: Required Date Reference:	646.3810 Bracket 9/23/13 : 9/23/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*	Accept		U9000 Cust Item II Customer:		100)* s	Setup Star Stop	IV	S1* S2*
Approvals:		an:	Date:			Da			F	Run Star Stop		R1* R2*
Sequence ID/ Work Center I 130 *130* QC Quality Control	D	Operation Description QC8- Inspect parts - secon	nd check	Set Up/ Run Hour: 0.00	ь Д. а	Tool ID	Tool#	Plan Code	Accept Qty 26	Reject Qty	Reject Number	Insp. Stamp OAS Q8
*140 *140* Outsource4 Outsource process	- Anodize	1- Black Ano 2- PRIME AS	ATG: 217Y3 dize as per Dwg 646.3800 S PER DWG, SEE NOTE	#2					<u>C</u> Z	131101	/ <u>+8</u>	- J.G
150 *150* Packaging		Certification (Receive & Inspect for Dar	of Comformity is required mage & Mat'l Certs	0.00					/-] - 13/4	/	(25)

Packaging

											DQA:	Dat	e:	
NCR:	es/	/ No				WORK ORDER NON-	COP	VFORM	AANCE / UPC	DATE				
· · · · · ·											QA Closed:	Dat	e:	
Nork Orde	er:					DISPOSITION				AGAINST DE	EPARTMENT	/PROCESS		
Part N	•		***************************************			Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor. re/Packaging		neering Quality Other
NCR I	No.			·		Work Order Update	1		Large Fab	Composite		Supplier		
Root					Descri	iption of work order update		Initial	Acti	ion	Sign &			·*·
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	ı QC	Inspector
oc/Data										-				
quip/Tooling														
perator									}					
faterial														
etup								ł						
ther														
rocess														
upplier								!				ĺ		
raining														
napproved														
						F	AUL	T CATE	GORY					,
Landi	ng (Gear				General		_			_	_		
		Bending				Bend		Grain			Ovalized	[Pressur	re/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance [Temper	rature/Cure
		Cracks				Broken/Damaged		Inspecti	on incomplete		Part Incorred	:t [Weld	
		Crushed/0	Crimped			Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong	Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved	_		
		Heat Trea	it			Countersink		Mislabe	led		Positioned V	/rong _		
		Inspection		Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other	
-		Ripples in	Bend			Drill Holes		Offset		_				
		Torque W	aves in E	xtrusio	n [Drawing		Out of (Calibration					
		Turning S	equence			Finish		Out of S	Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

Work Ord September-11-1				*106	805*							Page 3	
Item ID: Revision ID: Item Name:	646.3810 Bracket			Accept	*N900	040	100)* :	Setup	Start Stop	171.	S1* S2*	
Start Date: Required Date Reference:	9/23/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:					1 11 4		
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ate:		1	Run	Start Stop	*NI *NI	R1* R2*	
Sequence ID/ Work Center I 155 *155* QC Quality Control	D	Operation Description QC5- Inspect part comple Memo	eteness to step on W/O	Set Up/ Run Houbas 0.00 27 9-89	Tool ID	Tool #	Plan Code	Accept Qty Qty	Rej Qty		Reject Number	Insp. Stamp	
*180 *180* Packaging		Memo	SY AS PER APICAL MPP	0.00	AND REV***			264			<u></u>	DAS 26 9-89 -//- 7	7
190 *100*		QC21- Final Inspection -	Work Order Release	0.00				L	YR	m'	13/11/	//1	

0.00

Memo

Quality Control

13/11/11

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

										QA Closed:	Dat	te:
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update		l hern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Quality Other
Root				Descr	iption of work order update	Init	ial	Ad	ction	Sign &		
Cause	Da	te Step	Qty		or Non-conformance	Chief	Eng	Desc	cription	Date	Verification	n QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material												
Setup												
Other												
Process				ļ								
Supplier												
Training												
Unapproved		_ <u></u> l		į.								
	· · · · · · · · · · · · · · · · · · ·	<u> ·</u>			F	AULT (CATE	GORY				· · · · · · · · · · · · · · · · · · ·
Landi	ng Gear				General					•		_
	Bend	ling		_	Bend	∐ Gı	rain			Ovalized		Pressure/Forced
	Cent	re Not Conc	entric to	o/s	BOM/Route	На	ardwa	re	<u></u>	Over/Under	tolerance	Temperature/Cure
:	Cracl			<u> </u>	Broken/Damaged			on Incomplete		Part Incorre	1	Weld
	⊢	hed/Crimpe	d		Burrs			ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	;		_	Contamination	Шм	ainte	nance	<u></u>	Part Moved		
	Heat	Treat		<u> </u>	Countersink	Шм	islabe	led		Positioned V	Vrong	
	Inspe	ection Strip	in Tube		Cut Too Short	∐м	isreac	i		Power Loss/	Surge	Other
	Ripp	les in Bend		L	Drill Holes	∐ Of	ffset					
	Torq	ue Waves ir	n Extrusio	on L	Drawing	\square	ut of (Calibration				
	Turn	ing Sequenc	ce		Finish		ut of S	Sequence				
	Wav	e/Twist in T	uhe		Folio	1 10	utside	Dimensions				

Page 1 /1

September-11-13 11:44:04 AM

Work Order ID:

106805

Parent Item:

646.3810

Parent Item Name:

Bracket

Start Date: 9/23/13

Required Date: 9/23/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6A1.00X0.75X0. 125X0.060		Purchased	No			110	f	103.5550	0.1375	2.75	•		

7075T6 ANGLE 1.0" X .75" X .125" X .060"W

Loc Code Location Loc Qty MAT036 103.555 103.555 123947

₹ 8,156' /13/10/09

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-C	ONF	ORN	MANCE / UPDATE		•		
										QA Closed:	Date	:
Work Orde	.r.				DISPOSITION			AGAINST	r DEI	PARTMENT	PROCESS	
Part N	lo				Rework Scrap Use-as-is	Τł	۸ herm	Skid-tube Crosstube Machining Small Fab noforming Finishing			Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update	! 		Large Fab Composite	L		Supplier	
Root				Descri	ption of work order update	Initi	al	. Action		Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chief	Eng	Description		Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling							ł					
Operator							ĺ					
Material							i					
Setup												
Other												
Process							Ì					
Supplier												
Training												
Unapproved		1										
					F	AULT C	ATEC	GORY				
Landir	ng Gear				General							
[Bending				Bend	Gra	ain			Ovalized	Γ	Pressure/Forced
ſ	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hai	rdwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ins	pecti	on Incomplete		Part Incorred	t T	Weld
	Crushed/	Crimped			Burrs	Ins	tructi	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Ма	ainte	nance		Part Moved	_	_
	Heat Trea	et			Countersink	Mis	slabe	led		Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short	Mis	sread			Power Loss/:	Surge	Other
	Ripples in	n Bend			Drill Holes	Off	fset		_		_	

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order: 106805
,	
Description:	Part Number:
Inspection Dwg: - Rev:	Page 1 of 1

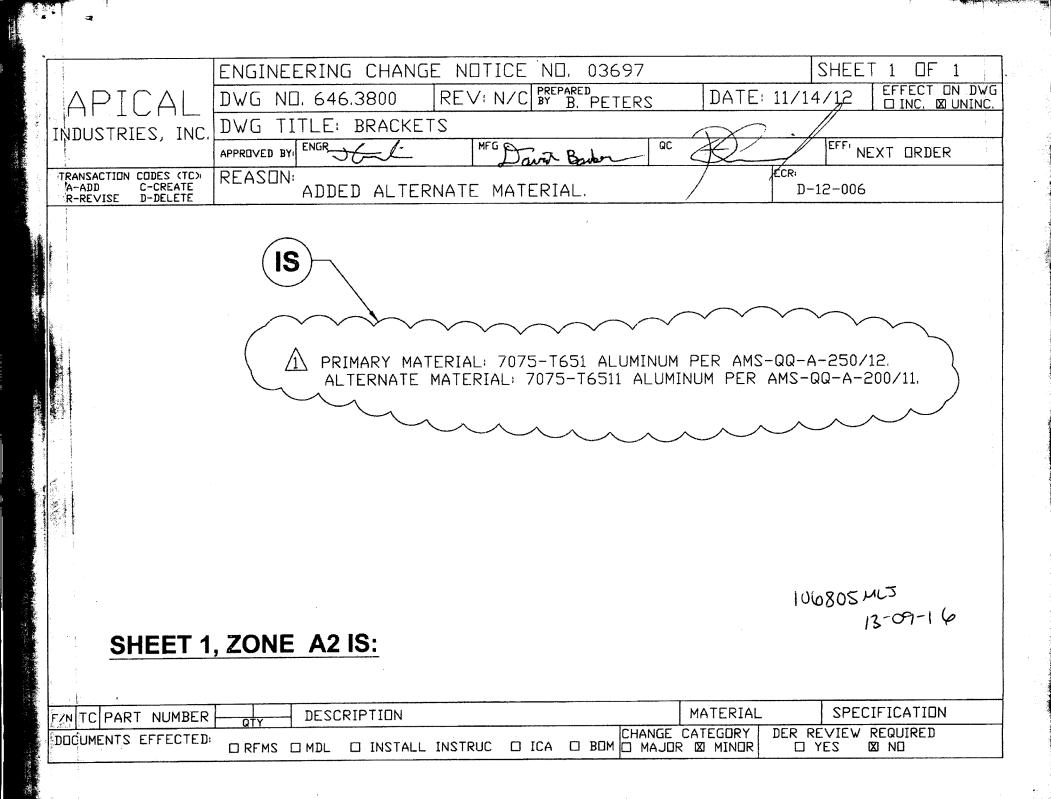
FIRST ARTICLE INSPECTION CHECKLIST

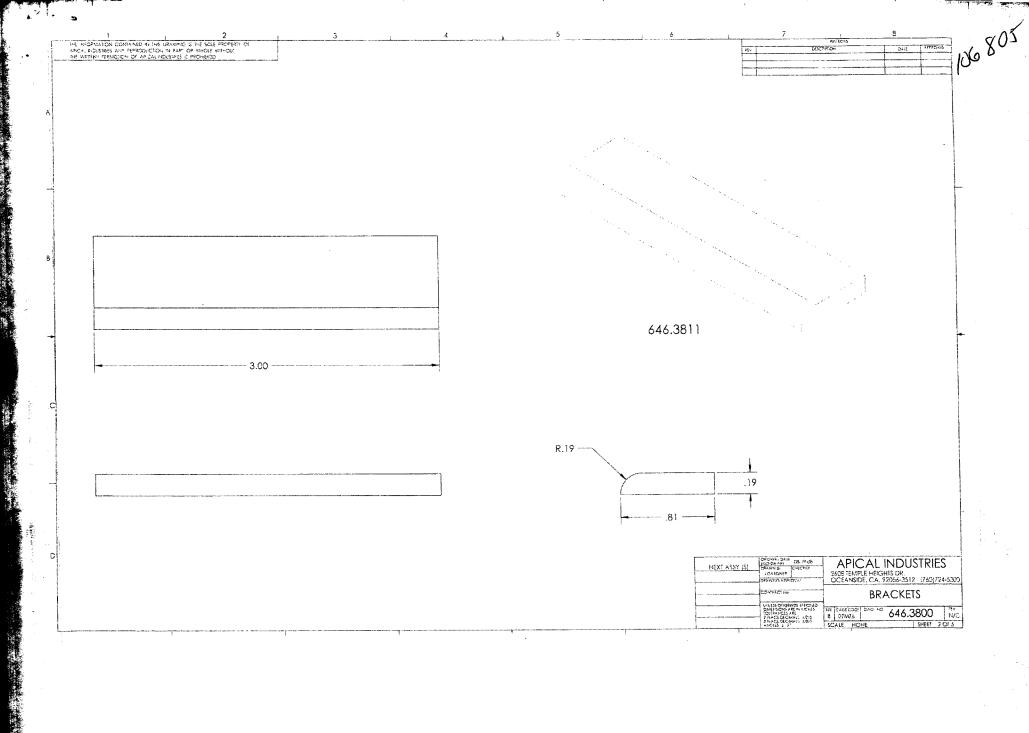
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3,50 B 0,010 0,44 0,88 R 0,06	+ 0.010	3.502			111-04	Vlsa
0000	- 0,010 - 0,004 - 0,001	3,502	/		111	' ' /
044	+ 0,010	0 443	/		(1)	, , ,
0.38	+ 0,010	0, 443 0, 888 0, 062 0, 382			111	, , ,
R 0.06	+ 0,010 + 0,010	0062			111	111
038	+ 0,010	0,382	/		1118-04	Vlan
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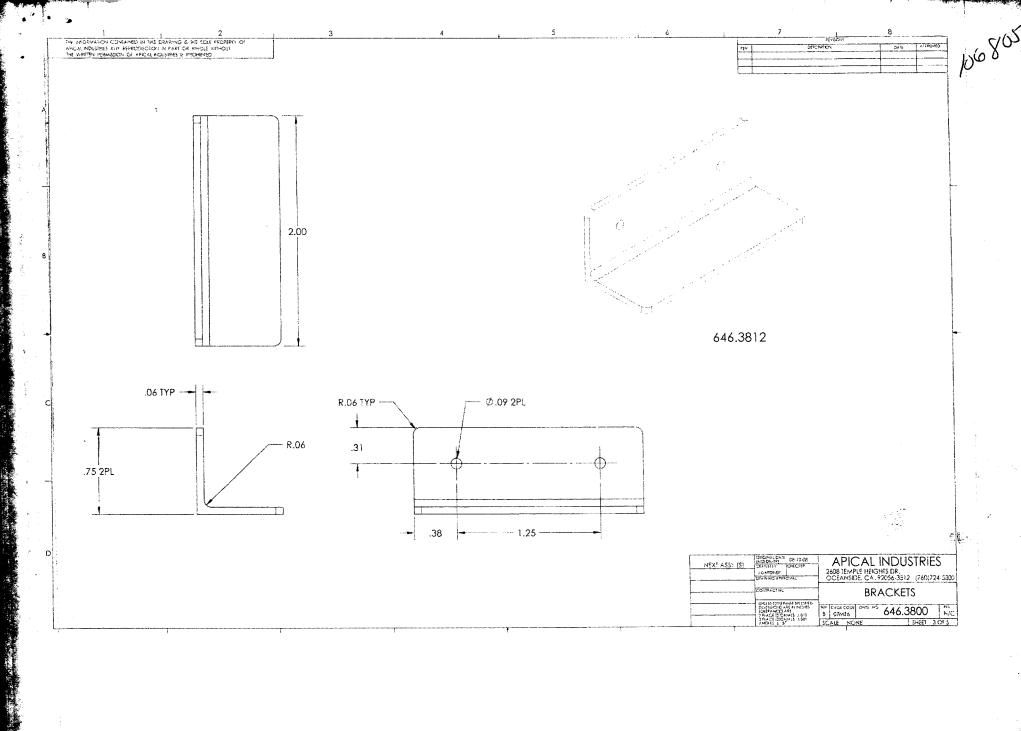
Measured by:	Audited by:	D.a DAS	Preliminary Approval:	
Date: /3/10/09	Date:	13/10/10 48	Date:	

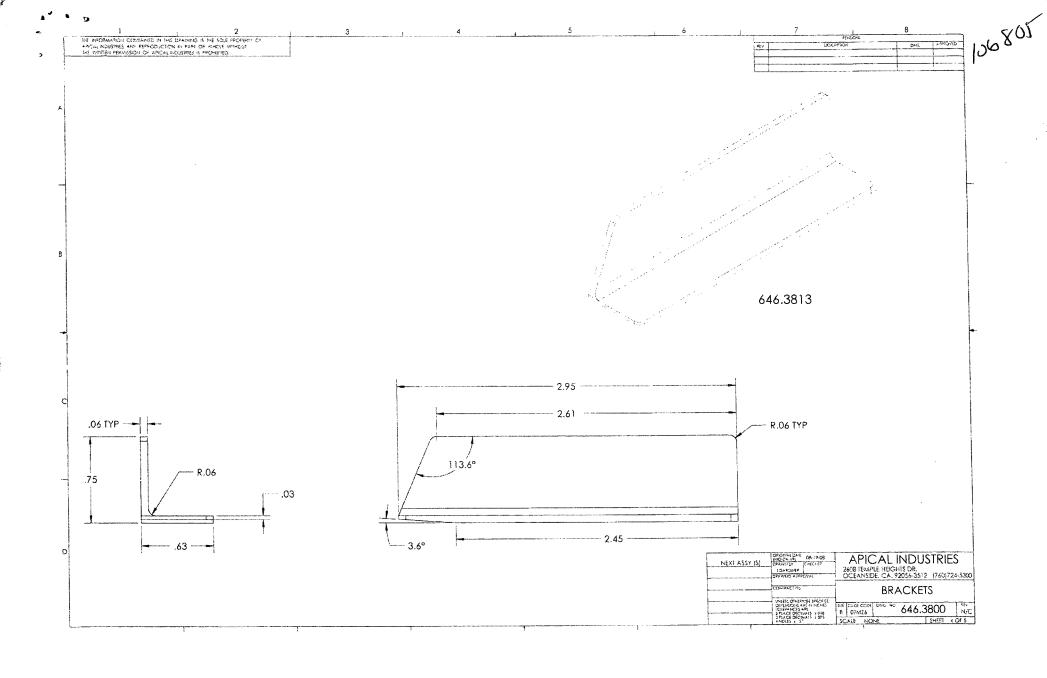
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

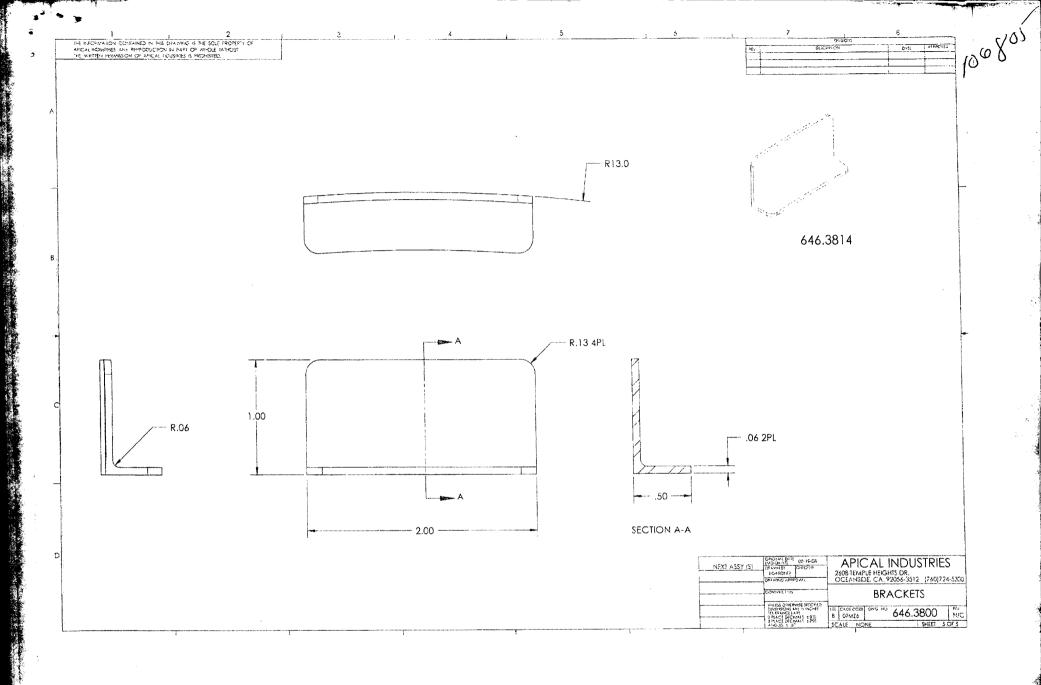
\$ 10.04.15













A.T.G: Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62723

Date: 06-Nov-13

То

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via					
Quantity	Description						
1	Part: ASST		Rev:				
lot	9 PCS 41232-200-002-005 (1.25) (ALREADY SHIPPED 31/10/13)						
	BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2						
	5 PCS 646.3210 (12.20) 21 PCS 646.3714 (15.75) 26 PCS 646.3810 (6.55) 18 PCS 646.3811 (6.55)						
	HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2						
	PRIME MIL-P-23377J TYPE I CLAS	SS N					
	PRICE IS PER PIECE Job: 20130688	PO: 21743	Line: -				
	Certificate of Con	formance					
,	A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.						
	ISO 9001 : 2008 REC ATG SALES-2010 TE						
	CERTIFIED SIGNATURE :						
	RECEIVER SIGNATURE :						
			*				